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D3913-041

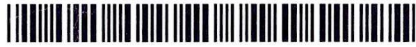
Job Sheet 193612



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/19

Job Tracking No:

Due Date: 5/20/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	5/20/19		0.00	10.00	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	5/20/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	1 pcs	5/20/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

Plex 4/17/19 10:14 AM Dart.Macdonald.Dara

			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
125 Handfinish - 2-1 Pressure-B4B	1 pcs	5/20/19	Handfinish - 2 - 1 - B4B	0.00 0.29
			Handfinish - 2 - 2 - B4B	
			Handfinish - 2 - 3 - B4B	
			Handfinish - 2 - 4 - B4B	
130 Powdercoat - 2 White GI(S)-B4B	1 pcs	5/20/19	Powdercoat - 1 - B4B	0.00 0.93
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
135 Packaging 1-1 - Pick Kit - B4B	1 pcs	5/20/19	Packaging 1 - 1 - B4B	0.00 0.00
			Packaging 1 - 2 - B4B	
			Packaging 1 - 3 - B4B	
			Packaging 1 - 4 - B4B	
			Packaging 1 - 5 - B4B	
			Packaging 1 - 6 - B4B	
			Packaging 1 - 7 - B4B	
			Packaging 1 - 8 - B4B	
			Packaging 1 - 9 - B4B	
			Packaging 1 - 10 - B4B	
			Packaging 1 - 11 - B4B	
			Packaging 1 - 12 - B4B	
			Packaging 1 - 13 - B4B	
			Packaging 1 - 14 - B4B	
			Packaging 1 - 15 - B4B	
			Packaging 1 - 16 - B4B	
			Packaging 1 - 17 - B4B	
			Packaging 1 - 18 - B4B	
			Packaging 1 - 19 - B4B	
			Packaging 1 - 20 - B4B	
			Packaging 1 - 21 - B4B	
			Packaging 1 - 22 - B4B	
			Packaging 1 - 23 - B4B	
			Packaging 1 - 24 - B4B	
			Packaging 1 - 25 - B4B	
			Packaging 1 - 26 - B4B	
			Packaging 1 - 27 - B4B	
			Packaging 1 - 28 - B4B	
			Packaging 1 - 29 - B4B	
			Packaging 1 - 30 - B4B	
			Packaging 1 - 31 - B4B	
			Packaging 1 - 32 - B4B	
			Packaging 1 - 33 - B4B	
			Packaging 1 - 34 - B4B	
			Packaging 1 - 35 - B4B	
			Packaging 1 - 36 - B4B	
140 QC 3	1 pcs	5/20/19	QC 3 - 10	0.00 0.00
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	

					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	5/20/19	0.00 0.50	Handfinish - 4 - 1 - B4B	all 19/5/23
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	
					Handfinish - 4 - 6 - B4B	
					Handfinish - 4 - 7 - B4B	
					Handfinish - 4 - 8 - B4B	
					Handfinish - 4 - 9 - B4B	
160	QC 5	1 pcs	5/20/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	DAS
					QC 5 - 43	19
					QC 5 - 49	9-09
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
170	Packaging 3-1 - Stock - B4B	1 pcs	5/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	

				Packaging 3 - 5 - B4B		
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
				Packaging 3 - 11 - B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B	DAS	
				Packaging 3 - 35 - B4B	21	
				Packaging 3 - 36 - B4B	9-88 MAY 23 2019	
180 QC 21 - SA	1	5/20/19	0.00	0.00	QC 21 - SA - 21	DAS
	pcs				QC 21 - SA - 70	21 MAY 23 2019
					QC 21 - SA - 53	9-88
Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect						
Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to						
fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913						
take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg						
110 - QC9- Inspect visual per QSI004- Fusion Welds						
120 - QC5- Inspect part completeness to step on W/O						
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings						
130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder						
coat						
135 - Pick Kit						
140 - QC3- Inspect Part Finish						
150 - Assemble as per dwg - Pick Kit						
160 - QC5- Inspect part completeness to step on W/O						
170 - Identify as per dwg & Stock Location: _____						
180 - QC21- Final Inspection - Work Order Release						

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5178393
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5172797
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5155103
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5178251
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5173011
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5165737
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5160068
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5176457
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5121276
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5173533
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5177081
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5174416
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	1x5170451 / 5179504
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5176948
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5176949
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5160068
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5162977
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5181089
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5166831
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F86435
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5155667
NAS1149F0332P	Washer	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5157462-1
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5155976
NAS1149FN832P	Washer	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	27	0
	D3913-1	1	9	0
	D3913-15	1	11	0
	D3913-3	1	1	0
	D3913-7	2	14	0
	D3913-9	1	4	0
	D3916-041	2	9	0
	D3916-5	3	9	0
	D4016-1	3	51	0
	D4017-7	3	28	0
	D4017-9	2	12	0
	D4020-11	2	2	0
	D4021-1	3	19	0
	D4034-041	1	1	0
	D4034-043	1	1	0
	D4672-1	2	17	0
	M304EX0.75-16F	32	1,112	0
150-Handfinish - 4-1-Assembly-B4B	AN3-10A	6	237	0
	D2931	2	741	0
	D4021-5	2	33	0
	MS20600-AD4W3	2	532	0
	MS21042L3	6	3,461	0
	NAS1149F0332P	12	5,275	0
	NAS1149FN832P	2	2,375	0

Part Specifications

Specifications could not be found.



Container No: S181764



Part: D3913 - 041

Job No: 193612

Serial No/Batch: S181764

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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